

Date: Wednesday, 11/06/2008 2:25:14 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR ARM
Job Number : 39822	
Estimate Number : 10505	
P.O. Number :	Part Number : D2010103
This Issue : 11/06/2008 S.O. No. :	Drawing Number : D2010 PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : PRELIM
Previous Run : 39504	Material :
Written By :	Due Date : 23/06/2008
Checked & Approved By : <u>JULIE 08.06.11</u>	Qty : <u>30</u> Um : Each
Comment : Est : F 02.08.21 Re-format; Added D2057 KJ/RF Est Rev:G 08-05-27 as per ECN1195P DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W049	304 RD Tube .500 x .049W
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**Comment:** Qty.: 1.5750 f(s)/Unit Total : 78.7500 f(s)

Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall

(M304TR0500W049)

Batch No: M108324SB 08/06/17

(30)

2.0	BRAKE NC	NC BRAKE
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**Comment:** BRAKE NC

Punch per Dwg. D2010-103-T1 and Spec Control Dwg D2727

Identify as D2010-103

SB 08/06/17

(30)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- Bend as per Dwg D2010 using bending Jig D2010-103T2

2- Deburr ends

FF 08-06-1908/06/18 DM

(30)

4.0	D2057	Plug
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Plug

Pick:

Qty Part Number Description Batch

1 D2057 Plug

B39826FF 08-06-19

(30)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

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Part Number: D2010103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-flare before installing plug as per dwg D2010

2-Install D2057 plug as per Dwg D2010

FF 08-06-19

(30)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/19 counted

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30
320 °F
11:00

m-h 08/06/20

(30X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

JS 08/06/20 (X30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5T228

JS 08/06/20 (X30)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/24

Job Completion



mf 08-06-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



